

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010869**Date Inspected:** 10-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As identified below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

North of Bay 14-

This Caltrans QA Inspector performed Magnetic Particle Testing (MT) verification of critical weld repairs previously tested and accepted by ZPMC for OBG Segment 8AE. For additional information see the TL-6028 MT report generated this date. The following welds were tested:

Longitudinal diaphragm horizontal stiffener to floor beam welds, SEG044B-051, 052 and 054

Internal horizontal stiffener to deck panel weld, SEG044E-153

Angle to WT stiffener flange weld, SSD24-PP62.5-049

Side panel stiffener to floor beam weld, CSD4-PP62-109

Bay 14-

Caltrans QA verified deck panel diaphragm to upper floor beam weld joint root gap measurements on OBG segment 11CE, weld SSD20-PP101-004 and 005.

North of Bay 14-

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Caltrans QA observed numerous areas base metal excavations of OBG segment 7DW side panels at temporary attachment removal areas. Excavations ranged from 50 to 75 mm in length and up to 3 mm in depth. See the attached photos below of excavation areas. Caltrans QA also observed FL3 floor beam to side panel Complete Joint Penetration welds with reinforcing fillet welds on the exterior have undercut areas have been ground up to 2 mm below flush at the side panel weld toe.

Shielded Metal Arc Welding (SMAW) of OBG Segment 7DW side panel to side panel Ultrasonic testing reject repair areas on weld, SEG039A-032. ZPMC welder was identified as 047864. ZPMC QC is identified as Li Ping. ZPMC CWI was identified as Li Yan Hua The welding appeared to be in conformance with welding procedure specification, WPS-345-SMAW-4G(4F)-Repair..

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
